

Work Order ID 66576

Page 1

Tuesday, February 22, 2011 11:06:57 AM

Item ID: D3255-041

Accept



Setup Start



Revision ID:

Item Name: Access Panel Assembly

Stop



Start Date: 2/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: CMF

Date: 11-02-22 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3255	Rev B

100

Large FabLarge Fab

Memo
1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD
Batch: 115928 2-Grind Welds FlushPL 11-04-09110

QC10- Inspect visual per QSI004- ground welds

0.00

S. WootenQuality Control

Memo

0.00

120

QC5- Inspect part completeness to step on W/O

0.00

S. WootenQuality Control

Memo

0.00

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Start Date:	2/23/2011	Start Qty: 4.00		Cust Item ID:			
Required Date:	3/9/2011	Req'd Qty: 4.00		Customer:			
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>MUS 126.</i>	0.00				4		<i>BL</i>	<i>11-4-11</i>
Powdercoat 	Memo	0.00							
Powder Coating	START TIME: <i>3:00</i>	10:05	OVEN TEMPERATURE: <i>300</i>	FINISH TIME: <i>10:35</i>					
140 	QC3- Inspect Part Finish	0.00				4		<i>BL</i>	<i>10-4-11</i>
QC 	Memo	0.00							
Quality Control									
150 	Small Fab	0.00				(4)			
Small Fab	Memo	0.00							
Small Fab	1-Bond D3255-5 gasaket to d3255-041 using Dow corning adhesive as per Dwg D3255-A/R 736 DOW CORNING ADHESIVE Batch: <i>M 11664</i>								<i>SB 1164118</i>

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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC5- Inspect part completeness to step on W/O

0.00

8/16/18

0.00

QC

Quality Control

170



Identify as per dwg & Stock Location: 170

0.00

Packaging

Packaging

Memo

0.00

(x4)
041

16/18 G

180



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

16/18 H

16/04/18

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Picklist Print

Page 1

Tuesday, February 22, 2011 11:06:54 AM

Work Order ID: 66576



Parent Item: D3255-041



Parent Item Name: Access Panel Assembly

Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-1 		Manufactured	No			100	Each	0.0000	1	4			B66573 → (4) P 11-04-07
Panel													
D3255-3 		Manufactured	No			150	Each	6.0000	1	4			B63587 → (4) P 11-04-07
Cap													
D3255-5 		Manufactured	No			100	Each	5.0000	1	4			
Gasket													

Location Loc Qty Loc Code

WA	2	
48315	2	
WA21	4	
63587	4	

SD 110417

4

Location Loc Qty Loc Code

ST044	5	
63588	5	

2
2

66574

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

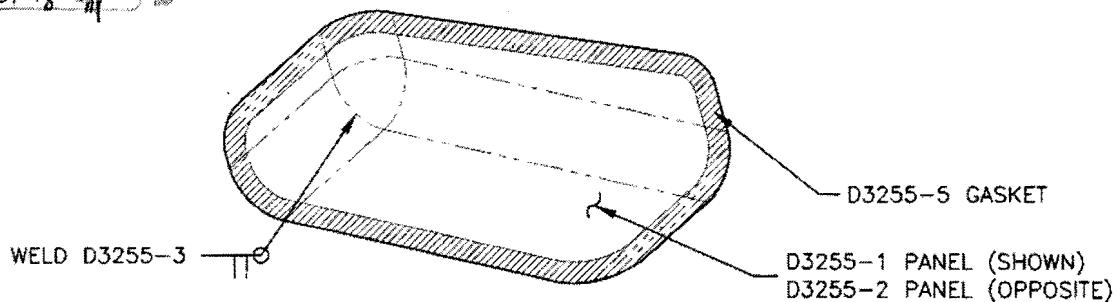
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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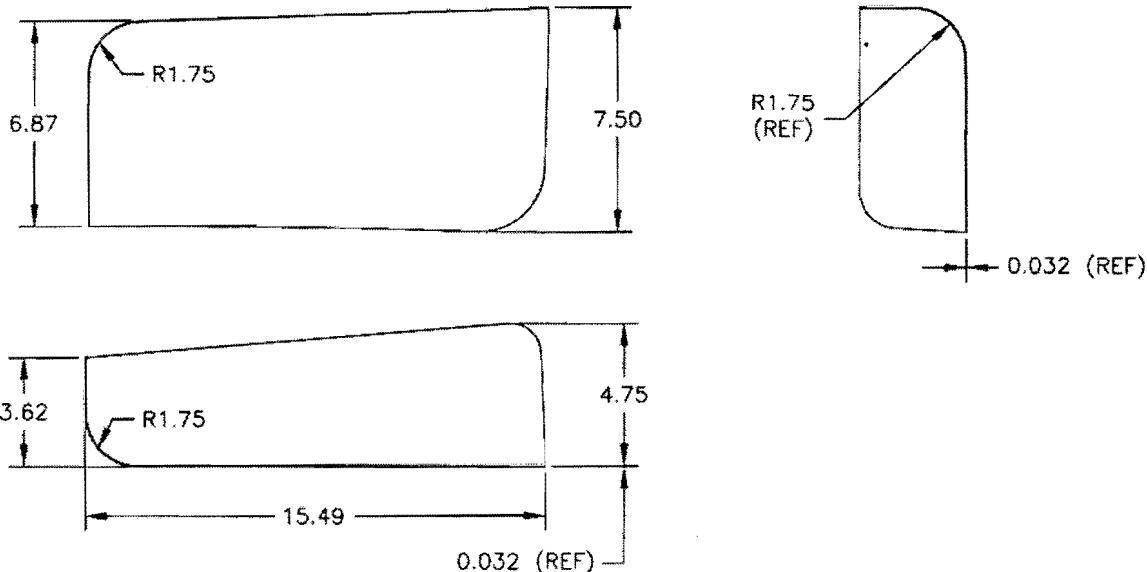


DESIGN <i>P</i>	DRAWN BY <i>P</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3255 REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY SCALE 1:6
A	04.01.27	NEW ISSUE
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098

RELEASED
05.01.18 *H*



**D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL
D3255-2 OPPOSITE**

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

(Handwritten notes: 1.005, 0.125, 0.125)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

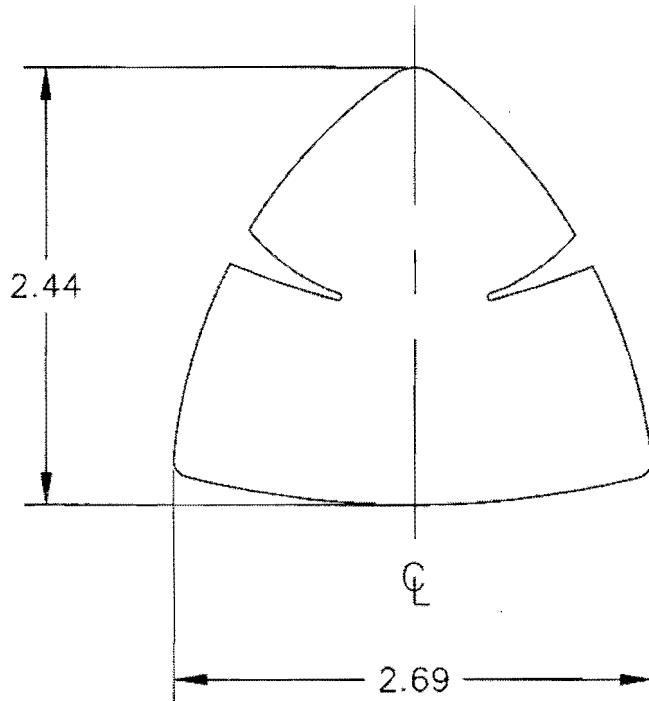
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-08 JF



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

XX
6652

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

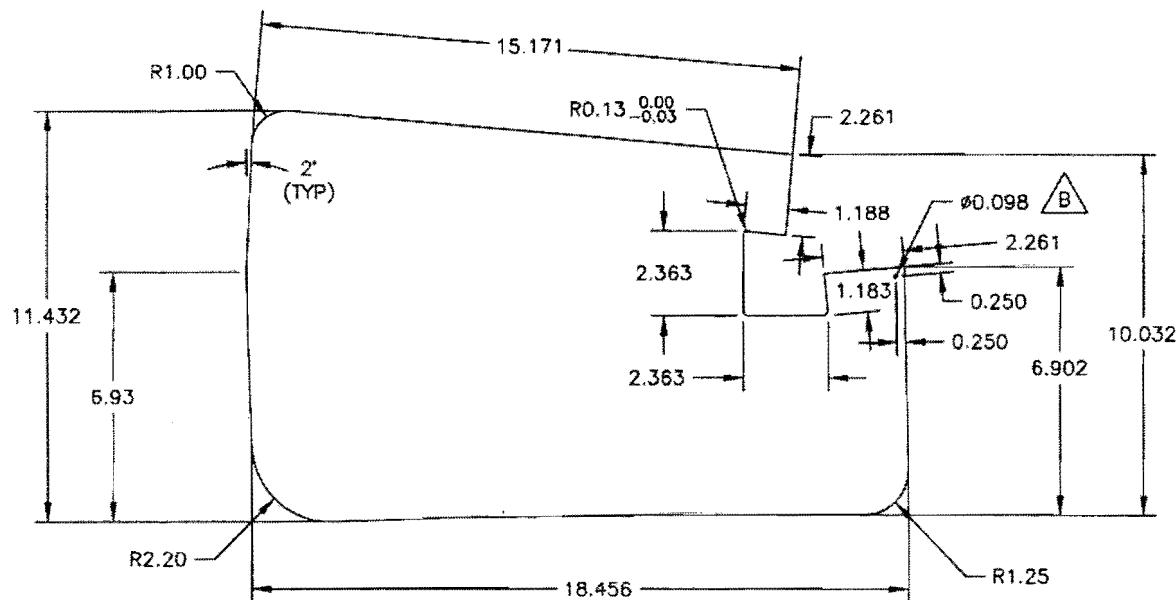
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PF</i>	DRAWN BY <i>FF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>HF</i>	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05-01-18 *HF*



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

6653

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

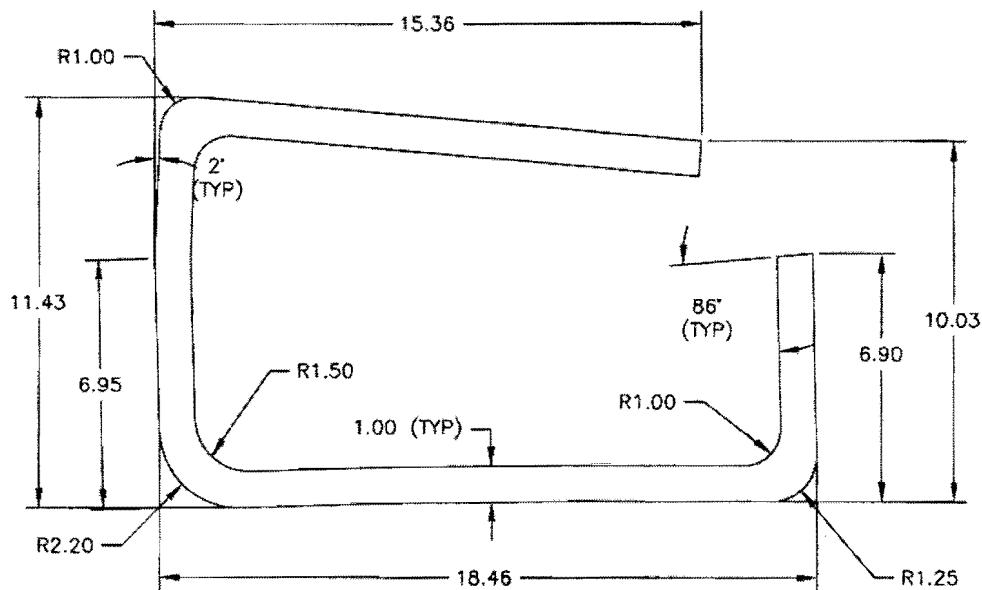
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DESIGN <i>JF</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>JF</i>	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5	

RELEASED
05.01.18 *JF*



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

#16916

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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